Wednesday, 23/07/2008 12:49:37 PM

Julie Lecocq

### **Process Sheet**

Customer

: CU-DAR001 Dart Helicopters Services

Job Number **Estimate Number**  : 40724 : 10327

P.O. Number This Issue

: 23/07/2008

: NC

Prsht Rev. : 11 First Issue

Previous Run

: 38558

: MACHINED PARTS Type

**Part Number** 

**Drawing Name** 

: D2741

**Drawing Number** 

: D2741 REV C

: BLADE

: N/A Project Number ; C

**Drawing Revision** 

**Material Due Date** 

: 22/08/2008

Qty:

40 Um:

Each

Written By

Checked & Approved By

Comment

00.11.15 : Est Rev: D

S.O. No. :

Removed P/O turning - in house

processEC

Est Rev: E

As Per Rev C 06-03-20

JLM

Est Rev: F

06.04.20 Added grinding after heat treating EC

**Additional Product** 

Job Number:



Seq. #: \

Machine Or Operation:

Description:

1.0

M4130NB0500X03000

4130 Bar 0.500 x 3.00

Comment: Qty.:

1.2118 f(s)/Unit Total:

48.4722 f(s)

4130 BAR 0.5 x 3.0".

Material: 4130 steel bar 0.50" x 3.00"

Batch: M 107 965

2.0

BAND SAW

BAND SAW



Comment: BAND SAW

Cut blanks 13.850" long +0.063" -0.000"

3.0

HAAS1



Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine per folio FA108

> 8/8/62

## Dart Aerospace Ltd

W/O:			WC	RK ORDER CHANG	SES				
DATE	STEP	PROC	EDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
			•	-					
Part No	:	PAR #:	_ Fault Categ	jory:	NCR: Yes	No DQ	A:	Date:	
				,	QA:	N/C Close	d:	_ Date: _	
NCR:		W	ORK ORDE	R NON-CONFORM	ANCE (NC	R)			
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Sec Action Description Chief Eng	tion B Sign Date	& Sect	cation ion C	Approval Chief Eng	Approval QC Inspector
			·	Chief Eng	Dut				
				•					
									·
				-					

NOTE: Date & initial all entries

Wednesday, 23/07/2008 12:49:37 PM Date: Julie Lecocq User: **Process Sheet** Drawing Name: BLADE Customer: CU-DAR001 Dart Helicopters Services Part Number: D2741 Job Number: 40724 Job Number: Description: Seq. #: **Machine Or Operation:** INSPECT PARTS AS THEY COME OFF MACHINE QC2 4.0 Comment: INSPECT PARTS AS THEY COME OFF MACHINE SECOND CHECK OC8 5.0 Comment: SECOND CHECK SMALL & MEDIUM FAB RESOURCE 1 SMALL FAB 1 6.0 Comment: SMALL & MEDIUM FAB RESOURCE 1 1-Deburr 40 2-Bend per Dwg D2741 INSPECT WORK TO CURRENT STEP QC5 7.0 Comment: INSPECT WORK TO CURRENT STEP **OUTSIDE SERVICES-MACH** 8.0 Comment: Sub-Contracting PURCHASING C208/08/25 Issue P/O: \_\_70 [] Harden material as per Dwg D2741 Min. Ultimate Tensile Strength = 152 ksi (34-40 HRC) Min. Yield Tensile Strength = 141 ksi Test report or Certification required PACKAGING 1 PACKAGING RESOURCE #1 9.0 Comment: PACKAGING RESOURCE #1 Receive and Inspect for transit damage Ensure Test report or Certification attached INSPECT WORK TO CURRENT STEE 10.0 QC5 wants Comment: INSPECT WORK TO CURRENT STEP SMALL & MEDIUM FAB RESOURCE 1 11.0 SMALL FAB Comment: SMALL & MEDIUM FAB RESOURCE 1 1-Pass in deburring machine 2-Grind off edges

#### Dart Aerospace Ltd

W/O:		WORK ORDER CH	ANGES				
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
				·~			
		· · · · · · · · · · · · · · · · · · ·			-		
Part No	<b>:</b>	PAR #: Fault Category:	NCR: Yes	No DQ	A:	Date: _	
			QA: I	N/C Close	d:	Date:	

NCR:	٠		VORK ORD	ER NON-CONFORMANC	E (NCR)				
		Description of NC		Corrective Action Section B			Approval	A 1	
DATE	STEP	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector
•									
			·	·					
				·.					
		·							

NOTE: Date & initial all entries

Wednesday, 23/07/2008 12:49:37 PM Date: -User: Julie Lecocq **Process Sheet** Drawing Name: BLADE Customer: CU-DAR001 Dart Helicopters Services Part Number: D2741 Job Number: 40724 Job Number: Description: Seq. #: **Machine Or Operation:** POWDER COATING POWDER COATING 12.0 10852 Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3 START TIME: **OVEN TEMPERATURE:** FINISH TIME: 13.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION PACKAGING 1 PACKAGING RESOURCE 14.0 Comment: PACKAGING RESOURCE #1 Identify and Stock Location 466 FINAL INSPECTION/W/O RELEASE QC21 15.0 Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W N. 59.12

## Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES		· · · · · · · · · · · · · · · · · · ·			
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No:	PAR #:	Fault Category:	NCR: Yes No DQA:	Date:
			QA: N/C Closed:	_ Date:

NCR:		\	WORK OR	DER NON-CONFORMANO	E (NCR)			
		Description of NC		Corrective Action Section B			Approval	Anneoval
DATE	STEP	Section A Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Chief Eng	Approval QC Inspecto	
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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	40724
Description: Blade	 Part Number:	D2741
Inspection Dwg: D2741 Rev: C		Page 1 of 1

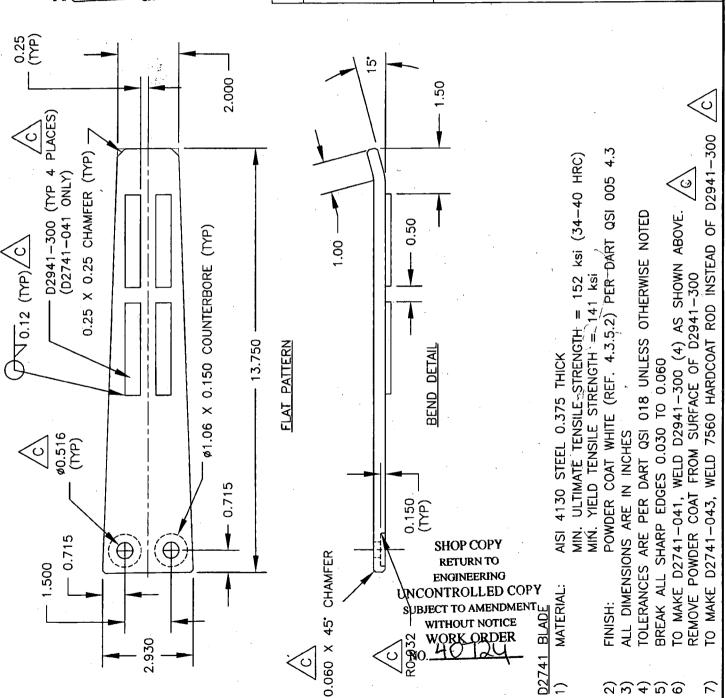
FIRST ARTICLE INSPECTION CHECKLIST							
	X Firs	st Article	Pro	totype	zak	A Transfer	
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments	
1.500	+/-0.010	1.800	6		2	4.	
0.715	+/-0.010	.714					
Ø0.516	+0.008/-0.001	0.516			1 // 1		
2.000	+/-0.010	2000				Wit Early	
13.750	+/-0.010	13.730			Tape.	***	
Ø1.06 x 0.150	+0.012/-0.001 x +/-0.010	01.06x 153				•	
2.930	+/-0.010	2.928	//		*	*	
0.375	+/-0.010	376					
0.25 x 0.25	+/-0.030	25x.25					
·							
			1				
4						·	

Measured by: 3	Audited by: M.A	Prototype Approval:	N/A
Date: 08/07/31	Date: 178/08/03	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	03.12.22	New Issue	KJ/RF	1
В	06.03.09	Revised per Rev. C	KJ/JLM	



	DESIG	PH	DRAWN BY	DART AEROSPACE USA, INC.
	CHEC	KED (1)	APPROVED _	DRAWING NO. REV. C
		#	#	D2741 SHEET 1 OF 1
١	DATE	<del></del>		TITLE SCALE
	06.0	)1.12		BLADE 1:3
	Α		98.04.16	NEW ISSUE
	В	e.,	98.09.01	CHANGE C'SINK TO C'BORE
	С		06.01.12	LARGER HOLE,ADD RADIUS AND CHAMFER ADD -041/-043 OPTIONS



0.54.00

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## **PACKING SLIP**

OAK 101974-1

HEAD OFFICE 1371 Speers Road, Oakvalle, Ontario Canada L6L 2X5 Tel: (905) 827-4171 Fax: (905) 827-7489

QUEBEC DIVISION 7450 rue Vérité Street, St. Laurent, Québec CANADA H4S 1C5 TEL: (514) 334-4240 FAX: (514) 334-6269

GST No.: R105468102

09/09/2008

MM / DD / YYYY

1

PAGE:

1DAR01

BILL TO:

DART AEROSPACE LTD. 1270 ABERDEEN ST.

HAWKESBURY, ON

ren iki 31/1/36

SHIP TO: DART AEROSPACE LTD.

1270 ABERDEEN ST.

HAWKESBURY, ON

K6A 1K7

K6A 1K7

F.O.B. SHIP VIA DATE SHIPPED ORIGIN 09/09/2008 TERMS JOB No. CUSTOMER P/O No. NET 30 DAYS PO00007011

87. 33. At 1

100

LN	PART NO	DESCRIPTION	UOM	QTY ORDERED	QTY SHIPPED	B/O QTY
		B40724	EA	40	40	0
	HARDENED TO 152 KSI 100% HARDNESS TESTE MATERIAL: 4130	D PER ASTM E-18, 34-40 HRC				
02	MC	MINIMUM CHARGE 150 LBS @ \$2.35/LB		1	1	0

No claims for shortage in weight or count will be entertained, unless presented within 5 working days after receipt of materials by customer.

 $x \in \mathcal{U}_{0}$ 







# **RELEASE NOTE**

GST No.: R105468102

OAK 101974-1

BILL TO:

HEAD OFFICE 1371 Speers Road, Oak Tile, Ontario CANADA L6L 2X5 Tel: (905) 827-4171 FAX: (905) 827-7489 2009 WYECROFT ROAD, UNIT B OAKVILLE, ONTARIO

CANADA L6I 6J4 TEL: (905) 827-7377 FAX: (905) 827-1380

QUEBEC DIVISION 7450 RUE VÉRITÉ STREET, ST. LAURENT, QUÉBEC CANADA H4S 1C5

TEL: (514) 334-4240 FAX: (514) 334-6269

09/09/2008 MM / DD / YYYY

PAGE:

1DAR01

DART AEROSPACE LTD.

1270 ABERDEEN ST. HAWKESBURY, ON

SHIP TO:

DART AEROSPACE LTD. 1270 ABERDEEN ST.

HAWKESBURY, ON

K6A 1K7

K6A 1K7

	T SHIP VIA	F.O.B.
DATE SHIPPED		ORIGIN
09/09/2008	JOB No.	TERMS
CUSTOMER P/O No.		NET 30 DAYS
PO00007011	J. J. Santa	

100000.					
PART No. DESC	RIPTION UOM	QTY ORD	QTY SHPD	TEST RESULTS	-
	EA	40	40		1

102741

B40724

Process Specifications:

Procedure: 4161

HARDENED TO 152 KSI MINIMUM

100% HARDNESS TESTED PER ASTM E-18, 34-40 HRC

MATERIAL: 4130

100% HARDNESS TESTED

40ecs = 36/37

I hereby certify that the material covered by this release note has been inspected and tested and conforms to all specifications relevant thereto in accordance with the conditions of the contract / or purchase order.

ON BEHALF OF VAC AERO INTERNATIONAL INC.

Authorized Q.C. Inspector



